

Date: Wednesday, 5/31/2006 7:35:43 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM
Job Number	: 27279		
Estimate Number	: 10335		
P.O. Number	: N/A	Part Number	: D2010104
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D2010 REV. C2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: C2
Previous Run	: 25641	Material	: N/A
Written By	: <i>SKA COMMENT: REBOW</i>	Due Date	: 6/10/2006
Checked & Approved By	: <i>06.05.31</i>	Qty:	<i>10</i> Um: Each
Comment	: Est A 04.02.17 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 9.4500 f(s)

Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall

(M304TR0500W035)

Batch No:

*M 100928**FF 06-06-07 10*

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg. D2010-104 and Spec Control Dwg D2727

Identify as D2010-104

FF 06-06-07 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-104T2

2- Deburr

FF 06-06-7 10

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Plug

*B 21675**FF 06.06.12 10*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D2057 plug as per Dwg D2010

FF 06.06.13 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: MIRROR ARM

Job Number: 27279

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-06-13

(10)

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

06-06-26

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/26

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST203

06/06/26

(10)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/27

(10)

Job Completion



06-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

ITEM NO.	DESCRIPTION	MATERIAL	QTY	UNIT	REMARKS
1	FE-0323EF	FASTENER			
2	CLAMP	.050 THICK			
3	SPRUE	.025 THICK			
4	PLUG	.001-T6 BAR			
5	ARM	CRES TUBE 30D+.035U			
6	BRACKET	2024-T3 .063 THK			

GENERAL NOTES:

- BEND RADIUS FOR 2024-T3 .063 THICK IS .188
- PAINT 101 MATTE BLACK
- TYPE 304 STAINLESS STEEL MAY BE SUBSTITUTED WITH TYPE 303 OR 316
- 2024-T3 MAY BE SUBSTITUTED WITH 2024-T3 CLAD (60-4-150-5) FINISH: POWDER COAT BLACK SANDTEX (4.5.3.7) PER PART Q305 4.5
- FE-0323EF (QTT4) INSTALL PER PEM INSTALLATION INSTRUCTIONS.

WART CODE SHALL BE MIN MAX 333

REPORT ALL DISCREPANCIES - DO NOT SCALE

REWORKS - LIMITS DIMENSIONS SHOWN

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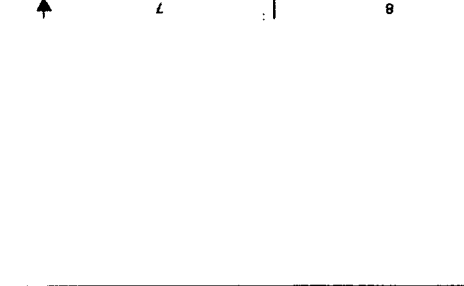
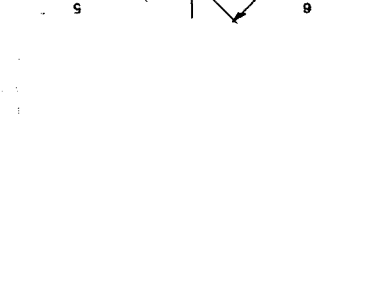
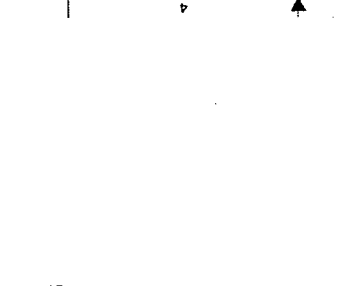
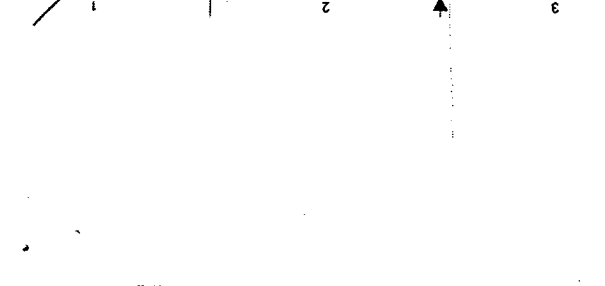
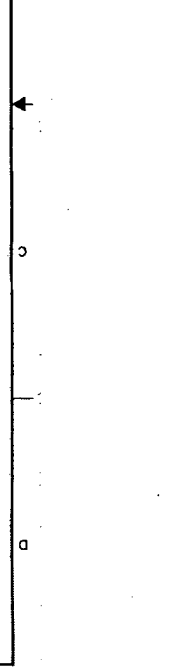
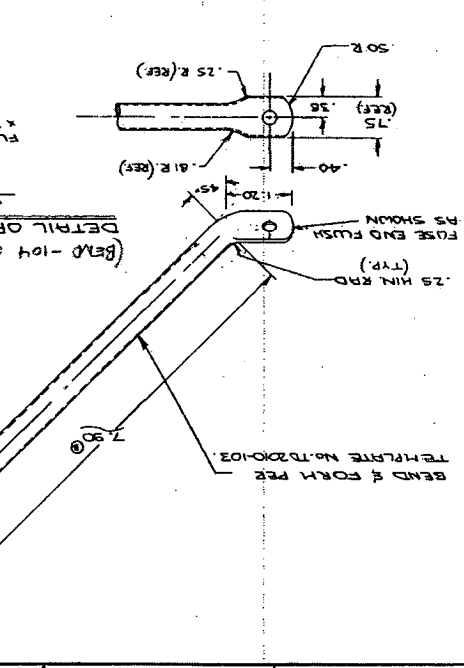
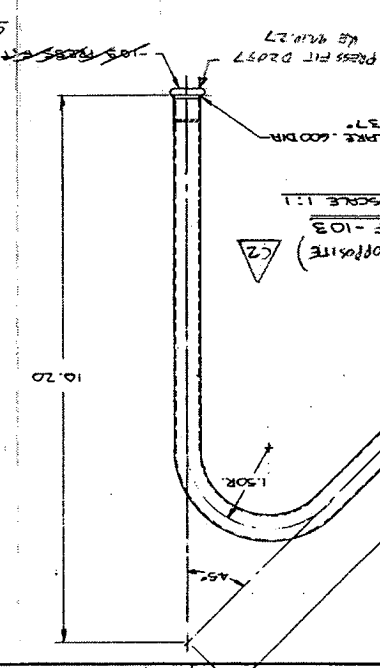
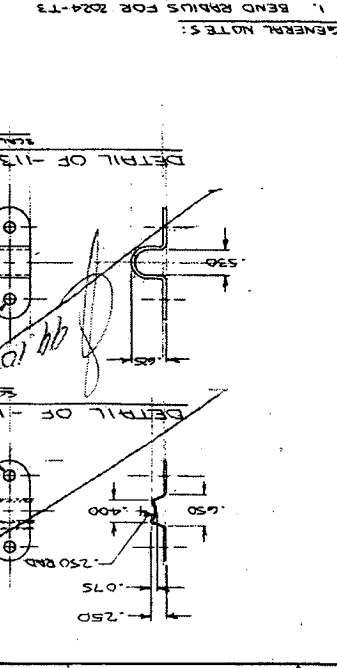
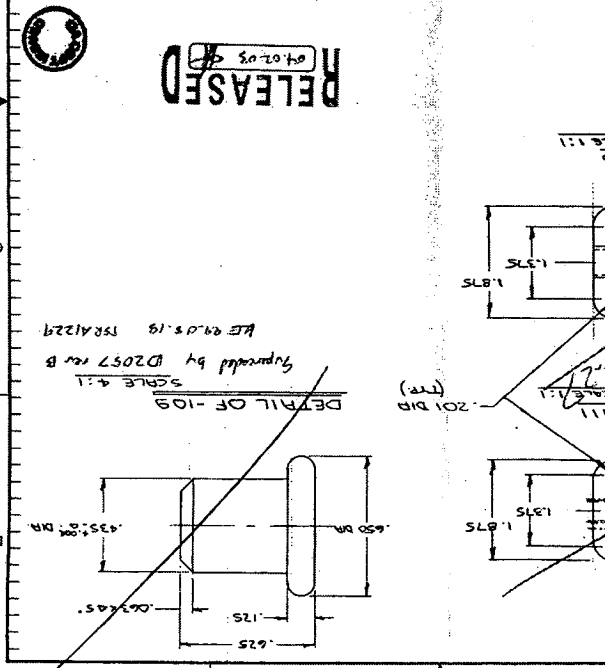
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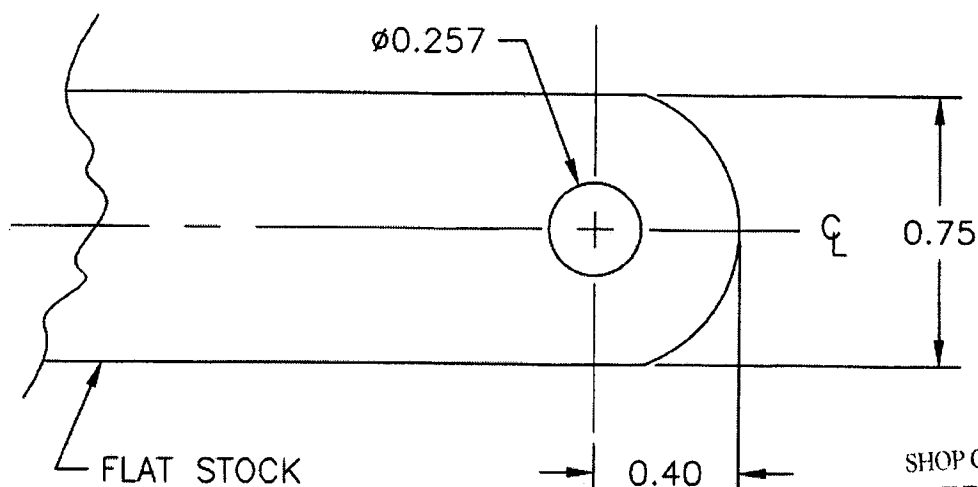
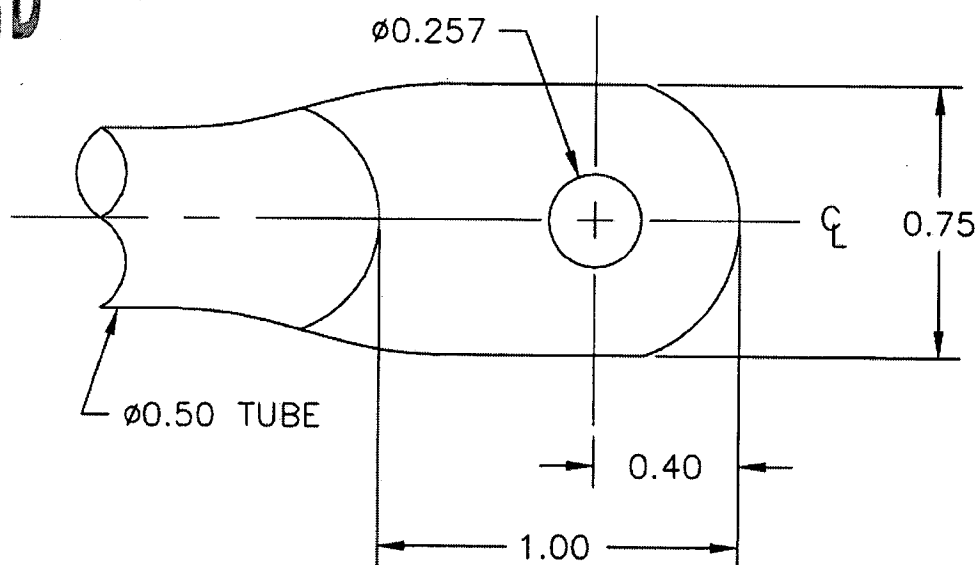
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>my</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8012

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98/03/06 KE



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